

Work Order ID 51328

Page 1

August 19, 2009 10:49:55 AM

Item ID: D2917-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle RH

Start Date: 08/19/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: YMFDate: 09-08-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2917	Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.00

ark 09/09/04

84 82PTO

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

0.00

Conventional Milling Machine

Memo

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

ark 09/09/04

84 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

ark 09/09/04

84 0

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2917-2

PAR #:

Fault Category: Machined Parts

NCR: Yes

No

DQA:

Date: 05.05.0

Resolution: Setup

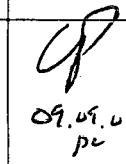
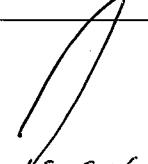
Disposition: Setup

QA: N/C Closed:

Date: 05.05.10

NCR: 51328

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
(A) 09/09/08	100	1 part scrap, the thickness wall are too small of .090" R.C. operator error, take the origins at the wrong place.	Initial PC	destroy and replace Qty 1 Batch: 51423	09/09/08	Y.A 09/09/08		
(B) 09.09.08	100	Saddle-to-skid holes are $\phi 0.449$	Initial PC QSI 042	Fit bushing too loose. Critical location. Scrap part.	09/09/08	Y.A 09/09/08 QSI 042		

NOTE: Date & initial all entries

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Start Date: 08/19/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

M.A 09/09/04

24 0



QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

UMO 09/09/08

24



HandFinish

Hand Finishing

Memo

0.00

1

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 09/09/08

4 6



Powdercoat

Powder Coating

Memo

0.00

START TIME: 3:30pm OVEN TEMPERATURE:
FINISH TIME: 3:00pm 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 51328

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August 19, 2009 10:49:55 AM

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Revision ID: B

Stop



Item Name: Saddle RH

Start Date: 08/19/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish



QC

Memo

BL 09-09-9
0.00
0.00

4

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PC 09/09 (Y)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/09 (Y)

MF 09-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 1

August 19, 2009 10:49:54 AM

Work Order ID: 51328



Parent Item: D2917-2RevB



Parent Item Name: Saddle RH

Start Date: 08/19/2009

Required Date: 08/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD 		Manufactured		No		100	Each	0.0000	4.0000 			

Saddle Billet

Batch # 57423 4 cmf 08/19/09

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order: 51328
Description: Saddle RH			Part Number: D2917-2
Inspection Dwg: D2917 Rev. A1			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.175	0.205		.188	.189	.188	.185		
B	0.090	0.110		.105	.098	.100	.090		
C	0.250	0.270		.258	.258	.260	.256		
D	1.599	1.619		1.611	1.611	1.611	1.609		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.282	.282	.282	.281		
G	1.385	1.400		1.387	1.390	1.390	1.387		
H	3.170	3.230		3.188	3.194	3.193	3.191		
I	0.175	0.217		.177	.181	.180	.180		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.501	1.503	1.503	1.503		
L	4.436	4.446		4.440	4.441	4.441	4.441		
M	0.257	0.262	DT8683	.259	.259	.259	.259		
N	1.225	1.235		1.232	1.229	1.229	1.229		
O	1.103	1.113		1.106	1.109	1.109	1.109		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.443	.443	.443	.443		
R	0.490	0.510		.500	.504	.500	.503		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.002	8.002	8.002	8.002		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.205	.201	.203	.201		
W	1.990	2.010		2.002	2.002	2.003	2.002		
X	0.760	0.765		.760	.760	.760	.760		
Y	0.307	0.312		.312	.311	.311	.311		
Z	0.615	0.635		.628	.630	.633	.633		
AA	0.177	0.197		.187	.187	.187	.187		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	CMF	Audited by:	H.A
Date:	09/09/04	Date:	09/09/04

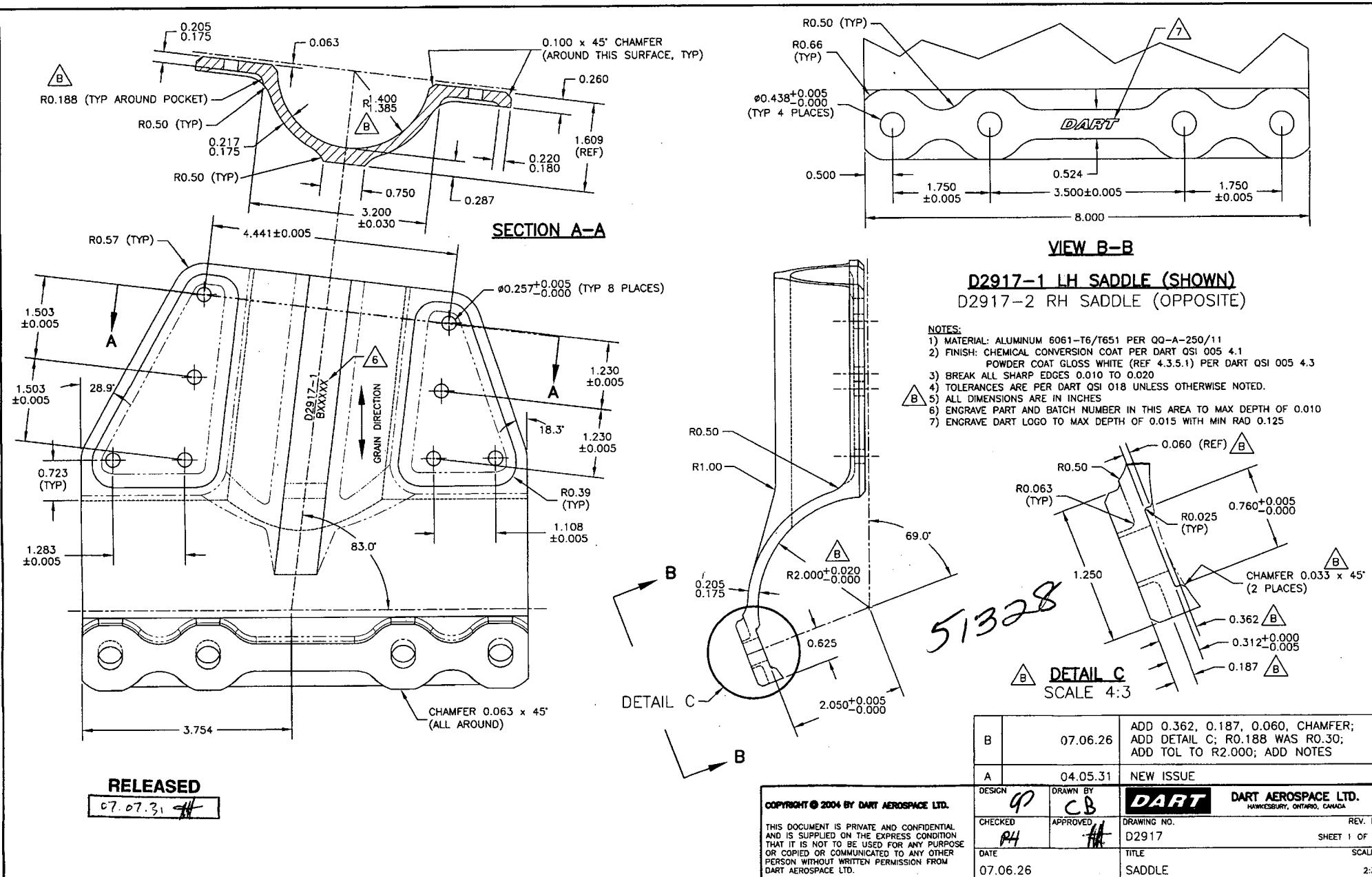
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	CMF

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